



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

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RBW6510G04631-6F
Job Sheet 198989



Part No: RBW6510G04631-6F

Job Qty: 2 pcs

Part Name: Reaction Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/8/19

Job Tracking No:

Due Date: 10/22/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6510G04631-6F Rev A IPP Rev. A 19.08.08 New issue DP Verify DD

Ship Via:

Bill of Materials



Dart Aerospace Ltd.
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Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
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Container No: S238878



Part: RBW6510G04631-6F

Job No: 198989

Serial No/Batch: S238878

Revision: A

Inspector:

Exp Date:

Instructions:

Date: 12/10/19

Job Routing								
Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup Hrs	Run Hrs	Workcenter / Supplier Lead Time	Sign-off
100	Small Fab - 1	2 pcs	10/22/19		0.00	0.67	Small Fab - 1	MCC
							Small Fab - 2	
							Small Fab - 3	
							Small Fab - 4	
							Small Fab - 5	
							Small Fab - 6	
							Small Fab - 7	
							Small Fab - 8	
110	QC 5	2 pcs	10/22/19		0.00	0.00	QC 5 - 10	DAS DEC 1 0 2019 9-89
							QC 5 - 12	
							QC 5 - 17	
							QC 5 - 18	
							QC 5 - 19	
							QC 5 - 22	
							QC 5 - 24	
							QC 5 - 3	
							QC 5 - 43	
							QC 5 - 49	
							QC 5 - 51	
							QC 5 - 58	
							QC 5 - 68	
							QC 5 - 9	
							QC 5 - 50	
							QC 5 - 30	
							QC 5 - 40	
							QC 5 - 61	
							QC 5 - 81	
120	Packaging 3-1 - Stock - B4B	2 pcs	10/22/19		0.00	0.00	Packaging 3 - 1 - B4B	DAS 28 9-89
							Packaging 3 - 2 - B4B	
							Packaging 3 - 3 - B4B	
							Packaging 3 - 4 - B4B	
							Packaging 3 - 5 - B4B	
							Packaging 3 - 6 - B4B	
							Packaging 3 - 7 - B4B	
							Packaging 3 - 8 - B4B	
							Packaging 3 - 9 - B4B	
							Packaging 3 - 10 - B4B	
130	QC 21 - FG	2 pcs	10/22/19		0.00	0.00	QC 21 - FG - 21	DAS 21 9-89 DEC 1 1 2019
							QC 21 - FG - 70	
							QC 21 - SA - 53	

Part Op 100 - Assemble as per DWG. See note 7 through 12. Sheet 1 and 2.

Descriptions: 110 - QC5- Inspect part completeness to step on W/O

120 - The tool must be packaged with a desiccant bag into a tight fitting sealed plastic bag as per DWG.

130 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
3896T31	Ferule 1/16 X 3/8" - Aluminum	4 Ea (2 ea)	100-Small Fab - 1	5199293
64 90272A423	Zinc Plated Steel Pan Head Phillips Screw #10-32 X 3/16" Long	2 Ea (1 ea)	100-Small Fab - 1	5206614
63 90273A192	Steel Phillips Flat Head Screw #8-32 x 3/8" Long	4 Ea (2 ea)	100-Small Fab - 1	5110442
64 90273A193	Steel Zinc Plated Phillips Flat Head Screw 82° Countersink #8-32 X 7/16" Long	6 Ea (3 ea)	100-Small Fab - 1	5206413
64 90905A655	316 SS Split Ring 15/16" ID. X 1-1/16" OD. X 1/8" Thick	2 Ea (1 ea)	100-Small Fab - 1	5206433
56 94505A115	17-4 PH SS T-Handle Quick Release Pin 3/16" Dia. X 1-1/2" Usable Length	2 Ea (1 ea)	100-Small Fab - 1	5206152
58 97840A460	18-8 SS Tab For Wire Rope Lanyard 1.40" Long X 1/2" Width X 1/16" Thick	2 Ea (1 ea)	100-Small Fab - 1	5198282
43 98410A110	Retaining Ring	4 pcs (2 ea)	100-Small Fab - 1	5206766
CL-2-C	Lanyard Wire	1.1660 ft (.583 ea)	100-Small Fab - 1	5192012
TBD 169 RBW6510G04631-6F-1	Reaction Weldment Assembly	2 pcs (1 ea)	100-Small Fab - 1	5236752
141 RBW6510G04631-6F-5	Spacer	2 pcs (1 ea)	100-Small Fab - 1	5215799
RBW6510G04631-6F-6	Bracket — 2 each	2 pcs (1 ea)	100-Small Fab - 1	5215693
RBW6510G04631-6F-7	Bracket Protector — 2 each	2 pcs (1 ea)	100-Small Fab - 1	5215788
RBW6510G04631-6F-8	Bracket Pin — 2 each	2 pcs (1 ea)	100-Small Fab - 1	5218069

Job Allocations

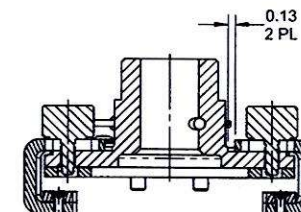
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	3896T31	4	704	0
	90272A423	2	0	0
	90273A192	4	100	0
	90273A193	6	0	0
	90905A655	2	16	0
	94505A115	2	0	0
	97840A460	2	25	0
	98410A110	4	0	0
	CL-2-C	1	1,168	0
	RBW6510G04631-6F-1	2	0	0
	RBW6510G04631-6F-5	2	0	0
	RBW6510G04631-6F-6	2	0	0
	RBW6510G04631-6F-7	2	0	0
	RBW6510G04631-6F-8	2	0	0

Part Specifications

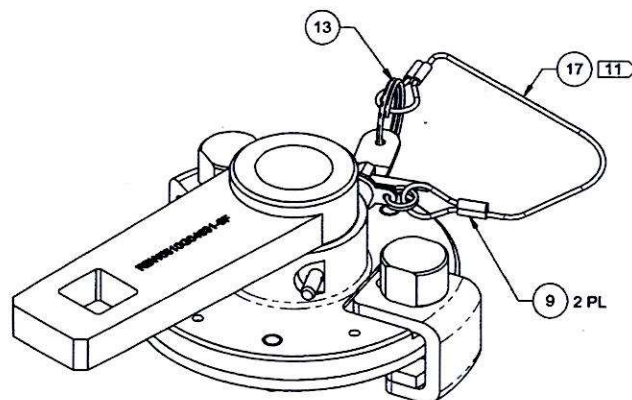
Specifications could not be found.

Plex 8/8/19 2:48 PM Dart.lajeunesse.marie

ITEM #	QTY	PART #	PART TITLE
-1	1	RBW6510G04631-6F-1	REACTION WELDMENT ASSEMBLY
-5	1	RBW6510G04631-6F-5	SPACER
-6	2	RBW6510G04631-6F-6	BRACKET
-7	2	RBW6510G04631-6F-7	BRACKET PROTECTOR
-8	2	RBW6510G04631-6F-8	BRACKET PIN
9	2	McMaster#3896T31 OR EQUIV.	ALUMINUM WIRE ROPE COMPRESSION SLEEVE 1/16" DIA. X 3/8" LG.
10	1	McMaster#90272A423 OR EQUIV.	ZINC PLATED STEEL PAN HEAD PHILLIPS SCREW #10-32 X 3/16" LG.
11	2	McMaster#90273A192 OR EQUIV.	ZINC PLATED STEEL PHILLIPS FLAT HEAD SCREW #8-32 X 3/8" LG. X 82° CSK.
12	3	McMaster#90273A193 OR EQUIV.	ZINC PLATED STEEL PHILLIPS FLAT HEAD SCREW #8-32 X 7/16" LG. X 82° CSK.
13	1	McMaster#90905A655 OR EQUIV.	316 SS SPLIT RING 15/16" ID. X 1-1/16" OD. X 1/8" THK.
14	1	McMaster#94505A115 OR EQUIV.	17-4 PH SS T-HANDLE QUICK RELEASE PIN 3/16" DIA. X 1-1/2" USABLE LG.
15	1	McMaster#97840A460 OR EQUIV.	18-8 SS TAB FOR WIRE ROPE LANYARD 1.40" LG. X 1/2" WIDTH. X 1/16" THK.
16	2	McMaster#98410A110 OR EQUIV.	BERYLLIUM COPPER RETAINING RING FOR 3/16" OD. X 0.168" ID. X 0.015" THK.
17	1	CARR-LANE#CL-2-C	NYLON COATED STEEL LANYARD 1/16" DIA.



SECTION B-B
(ROTATED 18° CW)



RBW6510G04631-6F REACTION ASSEMBLY

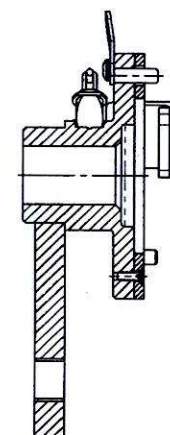
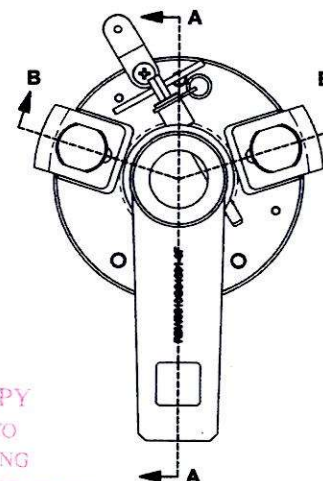
NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1"
X.XX = +/- 0.01" / +/- 0.5"
X.XXX = +/- 0.005" / +/- 0.1"
X.XXXX = +/- 0.0005" / +/- 0.05"
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS OF ITEMS 10 AND 12 THEN ASSEMBLE WITH ITEM -1, AND REMOVE EXCESS
- 9) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS OF ITEM 11 THEN ASSEMBLE WITH ITEM -6, AND REMOVE EXCESS
- 10) INSTALL ITEMS 10, 11, AND 12 HAND TIGHT
- 11) ASSEMBLED LANYARD LENGTH MUST BE 6" +/- 1", LANYARD MUST MOVE FREELY WHEN INSTALLING/REMOVING ITEM 14
- 12) ITEM -6 MUST SLIDE FREELY WHEN ITEM -8 IS LOOSENED
- 13) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

SHOP COPY
RETURN TO
ENGINEERING

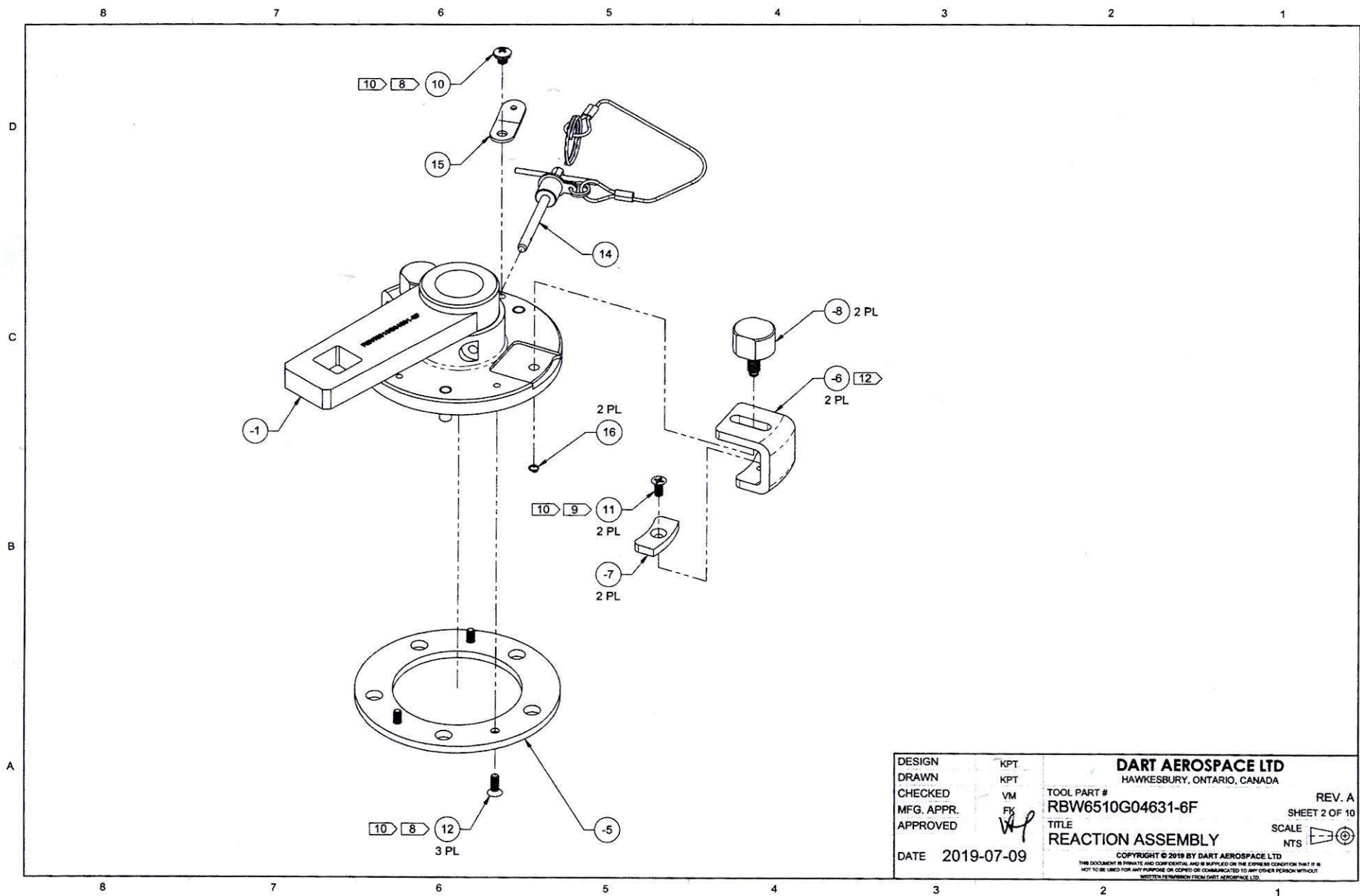
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 19898a m5
190809



SECTION A-A

A NEW ISSUE		19-807	KPT
REV.	DESCRIPTION	ECN #	BY
DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	FK	RBW6510G04631-6F	SHEET 1 OF 10
APPROVED	WFO	TITLE	SCALE
		REACTION ASSEMBLY	NTS
DATE	2019-07-09	COPYRIGHT © 2019 BY DART AEROSPACE LTD	
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DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA TOOL PART # RBW6510G04631-6F TITLE REACTION ASSEMBLY COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	REV. A
DRAWN	KPT		SHEET 2 OF 10
CHECKED	VM		SCALE
MFG. APPR.	FK		NTS
APPROVED			
DATE 2019-07-09			

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					